

5263948



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5785-1

Job Sheet 208154



Part No: D5785-1

Job Qty: 12 pcs

Part Name: Lid Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/12/20

Job Tracking No:

Due Date: 3/31/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: URF 20-522 DWG 5785 REV.A IPP REV:A NEW ISSUE 20.14.01 JV VERF:DD

Ship Via:

POSITIVE RECALL

EFFECTIVE 20/03/12 AUTH Jan

RELEASED _____ DATE _____



Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs	3/31/20		0.17	0.75	Waterjet - Flow		dc 20/03/13
							Waterjet - Omax		
110	QC 2	12 pcs	3/31/20		0.00	0.00	QC 2 - 1		dc 20/03/13
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Plex 3/12/20 8:56 AM Dart.Renwick.Jennifer

120 QC 8	12 pcs	3/31/20	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Packaging 3-1 - Stock - B4B 12 pcs		3/31/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	

DAS
40
9-89
MAR 17 2020

MAE

					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
140	QC 21 - SA	12 pcs	3/31/20	0.00 0.00	QC 21 - SA - 21	348
					QC 21 - SA - 70	21
					QC 21 - SA - 53	

Part Op 100 - Cut D5785-1 as per dwg Prog Rev: A Dwg Rev: A Deburr as required

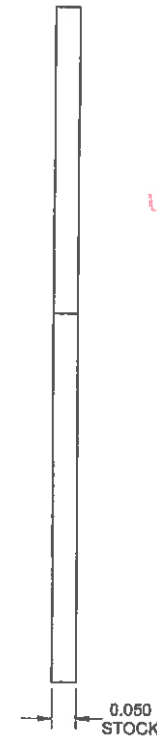
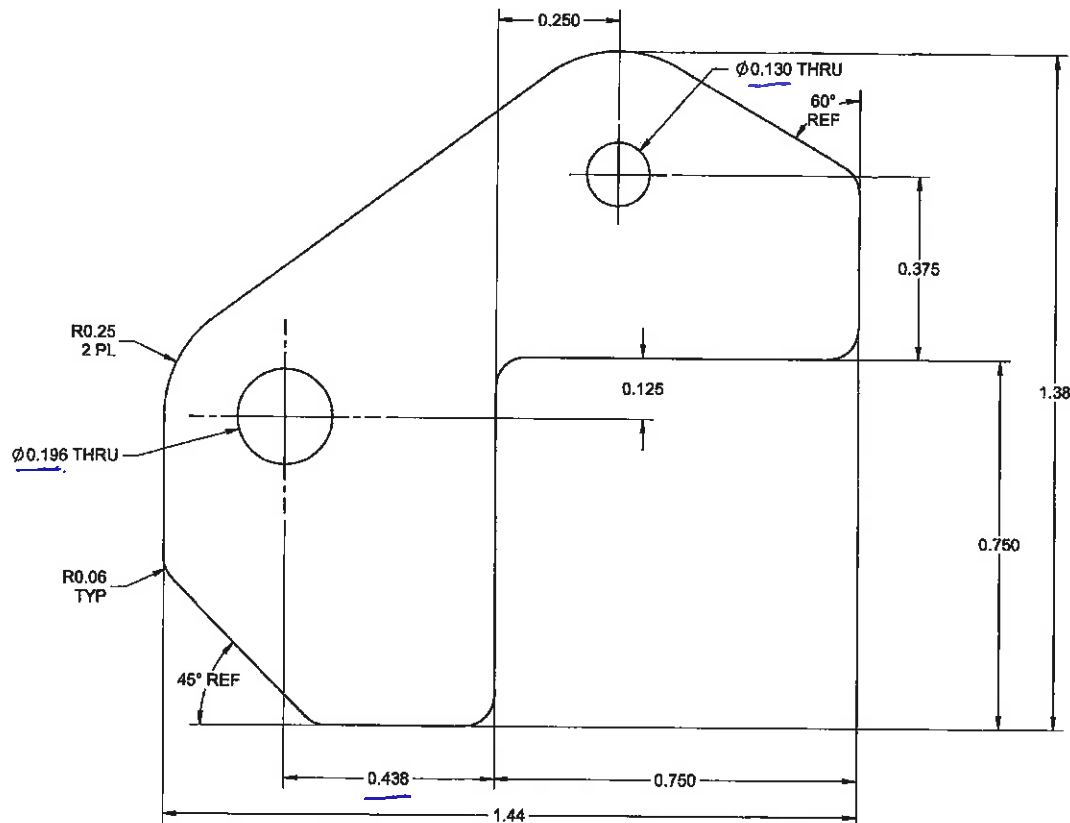
Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - (QC2- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: W7004)
 140 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	.1728 sf (.0144 ea)	100-Waterjet - Flow - 1	5243464

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	0	527	0

Part Specifications	
Specifications could not be found.	

Plex 3/12/20 8:56 AM Dart.Renwick.Jennifer



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 208154

D5785-1 BRACKET
(DERIVED FROM AERO DESIGN P/N 36273-01)

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED, #18 GA (0.050 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs
- 8) ALL NON-DIMENSIONED FEATURES WITHIN 0.030 OF "D5785-1-REVA.DXF"

RELEASED
2020 FEB 18 NO

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5785	SHEET 2 OF 3
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	HANDLE BRACKET	NTS
DATE	20.01.09	COPYRIGHT © 2020 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD		Work Order:	208154
Description: Lid Bracket		Part Number:	
Inspection Dwg: D5785-1	Rev: A	Page 1 of 1	

INSPECTION SHEET

[illegible]

Measured by:	<i>an</i>	Checked by:	<i>46</i> <i>8-89</i>	QC Inspector:	
Date:	<i>20/03/13</i>	Date:	<i>MAR 17 2020</i>	Date:	

Engineering Approval: (If necessary)		Date:
--	--	--------------

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045418**



Supplier: ACI001-VC
Acier Ouellette Inc.
935 Boul. Du Havre
Valleyfield
QC
J6S 5L1 Canada
Phone: 800 667 4248
Fax: 450 377 5696

Attention: Langevin, Melanie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045418

PO Date: 12/17/19

Due Date: 12/20/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments: QUOTE NO. SOU0230636

DEC 17 2019

Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		M6063T5C.75X.75W.125			6063-T5 Channel 0.750" x 0.750" x 0.125" wall receive ft	Firmed -		12/20/19	21 ft	21 ft	0 ft	\$1.006/ft	\$21.13
2		M6063T5A0.750W.063			6063-T5 Angle .750 X.750 X.063 WALL receive ft	Firmed -		12/20/19	21 ft	21 ft	0 ft	\$0.3757142/ft	\$7.89
3		M304S18GA			304/316 .050 Sheet : MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240	Firmed -		12/20/19	320 sf	320 sf	0 sf	\$5.6679375/sf	\$1,813.74

**ACIER OUELLETTE INC.**

935, Boul. du Havre
Salaberry de Valleyfield (Québec) J6S 5L1
Tél.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-667-4248
Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242

DELIVERY - CLIENT*CR 80*

C000184919

Billed to	Shipped to	Customer N°	CLI0001056
DART AEROSPACE LTD		Date	2019/12/17
1270 , ABERDEEN ST.	1270 , ABERDEEN ST.	Delivery date	2019/12/19
HAWKESBURY, Ontario, K6A 1K7	HAWKESBURY, Ontario, K6A 1K7	Your order N°	POHB045418
		Processed by	Josianne Bourdon
		Salesman	JOSIANNE BOURDON
Instruction	Delivery Route	Carrier	OUELLETTE VALLEYFIELD
F-M	5 + <i>WRAP</i> <i>Plots 4 V8</i>	Credit Terme	Net 30 Days

Product Description	Weight	Qty	UM	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 CHANNEL ALU 3/4 X 3/4 X 1/8 6063-T5 * CHAL-343418 1981 1 X 21' POHB045418 LINE 1 CAST; 19193172	6.17	21.00	PI_\$CLB		21'						
2 ANGLE ALU 3/4 X 3/4 X 1/16 C 6063-T5 * AAL-3434116 1361 1 X 21' POHB045418 LINE 2 CAST 41324	2.25	21.00	PI_\$CLB		21'						
3 SHEET SS 18G SS304-2B DART FESSD-18G3042B-V 12468 10 X 4' X 8' POHB045418 LINE 3 HEAT YU187124 PACKAGING	672.00	320.00	PI2_\$CLB		10X						
4 SHEET SS 11G SS304-2B (4 X 8) FESS-11G483042B 3402 2 X 4' X 8' POHB045418 LINE 4 HEAT D73E	336.00	64.00	PI2_\$CLB		2X						
5 SHEET SS 14G SS304-2B (4 X 8) FESS-14G483042B 3412 2 X 4' X 8' POHB045418 LINE 5 HEAT LZ25HC10	209.98	64.00	PI2_\$CLB		2X						

LINE 3

MATERIAL RECEIPT INSPECTION FORM

PCH13045418

MATERIAL: M304S/PCAPO / BATCH NO.: PCH13045418DATE: DEC 24 2019

S243464

MATERIAL CERT REC'D: YESTHICKNESS ORDERED: .050QUANTITY RECEIVED: 3205ATHICKNESS RECEIVED: .050QUANTITY INSPECTED: 3205ASHEET SIZE ORDERED: 4' x 8'QUANTITY REJECTED: 45ASHEET SIZE RECEIVED: 4' x 8'

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	CIRCLED SPOTS ON SHEET (1)
CORRECT FINISH	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	
CORROSION	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	
CORRECT GRAIN DIRECTION	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	
CORRECT MATERIAL PER M-DRAWING	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	ASTM A240
CORRECT THICKNESS	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	
PHOTO REQUIRED	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	
CORRECT REF # TO LINK CERT	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	HIC Y0187124
CORRECT MATERIAL IDENTIFICATION	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	
CORRECT M# ON THE MATERIAL	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	
DOES THIS REQUIRE AN EXTRUSION REPORT	<input checked="" type="checkbox"/> Y <input type="checkbox"/> N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>82</u> <u>6-89</u>	SIGNED OFF BY: _____
DATE: <u>DEC 24 2019</u>	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

LINE 3

M/T YU187124

M304S18GA

SPECIFICATION CONTROL DRAWING

PURCHASE MATERIAL: AISI 304/316 SS SHEET
ANNEALEDDAS
82
9-89

DEC 24 2019

SPECIFICATION: MIL-S-5069
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240

FINISH:

FINISH	DART M-NUMBER IDENTIFIER
UNPOLISHED No. 1	1P
UNPOLISHED No. 2D	2D
UNPOLISHED No. 2B	NONE
POLISHED No. 3	3P
POLISHED No. 4	4P
BUFFED No. 6	6P
BUFFED No. 7	7P
BUFFED No. 8	8P

PART NUMBER: M304S TT GA #P
[GA]WHERE "TT" = GAUGE THICKNESS
WHERE "#P" = FINISH IDENTIFIEREG. 16 GAUGE SS SHEET 2B FINISH = M304S18GA
EG. 16 GAUGE SS SHEET No. 4 POLISHED = M304S16GA4P

GAUGE THICKNESS REFERENCE:

GAUGE	NOM. THICK. (IN)	THICKNESS RANGE (IN)
26	0.01875	0.0178 - 0.019
25	0.021875	0.0199 - 0.023
24	0.025	0.024 - 0.026
23	0.028125	0.027 - 0.029
22	0.03125	0.030 - 0.032
21	0.034375	0.033 - 0.035
20	0.0375	0.036 - 0.040
19	0.04375	0.041 - 0.046
18	0.050	0.047 - 0.052
17	0.05625	0.053 - 0.058
16	0.0625	0.059 - 0.066
15	0.0703125	0.066 - 0.072
14	0.078125	0.073 - 0.083
13	0.08375	0.084 - 0.098
12	0.109375	0.099 - 0.114
11	0.125	0.115 - 0.130
10	0.140625	0.131 - 0.145
9	0.15625	0.146 - 0.160
8	0.171875	0.161 - 0.176
7	0.1875	0.182 - 0.194
6	0.2031	0.194 - 0.212
5	0.2188	0.201 - 0.228
4	0.2344	0.225 - 0.243
3	0.2500	0.238 - 0.262
2	0.2656	0.254 - 0.278
1	0.2813	0.269 - 0.293
0	0.3125	0.301 - 0.325

RELEASED

2015 FEB 04

ECN 15-522 97

D	ADDED GAUGES 0-7.	AJS	15.01.06
C	DEFINED FINISH OPTION (ZN C8) AND EXAMPLE OF MATERIAL FIN WITH FINISH OTHER THAN 2B (ZN B5).	MB	12.09.20
B	REFORMAT DWG. ADD ASTM/ASME SPECS (ZN D6-1), ADD GAUGE REF (C8-1), REF PAR 08-020A	CP	09.06.01
A	NEW ISSUE	DS	01.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		M304S	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		304/316 SS SHEET	NTS
DATE	15.01.06	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL - NO - SUPPLY TO OR THE EXPRESS - CONDITION THAT IT IS AND TO BE USED FOR THE PURPOSES OF THE ORIGINAL - CASE - TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD	

FESS-18G483042B

TRA 3686 52742

MILL TEST CERTIFICATE

Steel Grade: AISI 304L
 Date: 2018/07/25
 Invoice No.: SQCAEW8602TE6
 Surface Finish: 2B
 Page: P02/P04
 Goods: STAINLESS STEEL COLD ROLLED SHEETS
 Specification: ASTM A240/A480
 Certificate No.: PTTW028604TE6

Product ID	Chemical Composition (%)										Mechanical Properties					
	C	Si	Mn	P	S	Ni	Cr	N				Tensile Test			Hardness Test	
												Y.S. (Mpa)	T.S. (Mpa)	EL (%)	HRB	HV
75S43073B-23	0.018	0.360	0.760	0.037	0.004	8.01	18.09	0.038				297	647	50.0	82	162
75S43073B-24	0.018	0.360	0.760	0.037	0.004	8.01	18.09	0.038				297	647	50.0	82	162
75S43476-7	0.029	0.330	0.930	0.035	0.009	8.07	18.05	0.040				268	625	56.0	82	162
75S43476-8	0.029	0.330	0.930	0.035	0.009	8.07	18.05	0.040				268	625	56.0	82	162
75S43476-9	0.029	0.330	0.930	0.035	0.009	8.07	18.05	0.040				268	625	56.0	82	162
75S43476-A	0.029	0.330	0.930	0.035	0.009	8.07	18.05	0.040				268	625	56.0	82	162
75S43476-B	0.029	0.330	0.930	0.035	0.009	8.07	18.05	0.040				268	625	56.0	82	162
75S43476-1	0.029	0.330	0.930	0.035	0.009	8.07	18.05	0.040				268	625	56.0	82	162
75S43476-2	0.029	0.330	0.930	0.035	0.009	8.07	18.05	0.040				268	625	56.0	82	162
76S87832A-1	0.024	0.380	1.370	0.029	0.002	8.03	18.30	0.036				341	683	52.0	90	191
Product ID	Heat No.		SIZE					PCS		Remarks						
75S43073B-23	YU280024		16GA X 60" X 120"					21		REFERRING TO ASTM SPEC PO NUMBER: 18-P-266 LG NUMBER: DC HMN812260 OBL NUMBER: KHHMTRJ7829 CONTAINER NUMBER: MEDU7714189, MEDU6166285 Manager Of QA Dept. K. C. W.						
75S43073B-24	YU280024		16GA X 60" X 120"					20								
75S43476-7	YU187124		18GA X 48" X 96"					49								
75S43476-8	YU187124		18GA X 48" X 96"					49								
75S43476-9	YU187124		18GA X 48" X 96"					49								
75S43476-A	YU187124		18GA X 48" X 96"					49								
75S43476-B	YU187124		18GA X 48" X 96"					54								
75S43476-1	YU187124		18GA X 48" X 120"					33								
75S43476-2	YU187124		18GA X 48" X 120"					33								
76S87832A-1	LZ256A09		18GA X 60" X 120"					30								

We hereby certify that material described herein has been manufactured and tested with satisfactory results in accordance with the requirement of the above material specification.

Heat: YU 187124

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Description Work Order Deviation		Disposition			
Root Cause Operator <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Preservation <input type="checkbox"/> Material <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Human Factors <input type="checkbox"/>		FAULT CATEGORY <div style="display: flex; justify-content: space-between;"> <div> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
		Other/Details:			